

Date: Tuesday, 24/06/2008 2:17:54 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MIRROR ARM
Job Number	: 40046		
Estimate Number	: 10335		
P.O. Number	:	Part Number	: D2010104
This Issue	: 24/06/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2010 REVD
First Issue	: //	Project Number	: N/A
Previous Run	: 39823	Drawing Revision	: D
Written By	:	Material	:
Checked & Approved By	: <u>JW 08.06.24</u>	Due Date	: 27/06/2008
Comment	: Est A 04.02.17 New issue KJ/JLM Est Rev:B 08-05-27 as per ECN1195P DD verified by:EC Est Rev:C 08-06-20 rev.D as per dwg DD verified by:EC		

Qty: 75
 80- Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W049	304 RD Tube .500 x .049W
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Comment: Qty.: 1.5750 f(s)/Unit Total : 94.5000 f(s)
 Material: 304/316 SS tubing 0.500" Dia. x 0.049" wall
 (M304TR0500W049)

Batch No: M 108324

SB 08/06/25 (75)

2.0	BRAKE NC	NC BRAKE
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Comment: BRAKE NC
 Punch per Dwg. D2010-104 and Spec Control Dwg D2727
 Identify as D2010-104

SB 08/06/25 (75)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 1- Bend as per Dwg D2010 using bending Jig D2010-104T2
 2- Deburr ends

FF 08-06-25 (75)

B 08/06/25

4.0	D2057	Plug
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 60.0000 Each(s)
 Plug
 batch: B39826 (x17)

/B 40048 (x58)

FF 08-06-27 75

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1- flare before installing plug as per dwg D2010

FF 08-06-27 (75)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 24/06/2008 2:17:54 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR ARM

Job Number: 40046

Part Number: D2010104

Job Number:



Seq. #:

Machine Or Operation:

Description :

2- Install D2057 plug as per Dwg D2010

PF 08-06-27

(75)

6.0

QC5

INSPECT WORK TO CURRENT STEP



08/06/27 (75)



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



m162316



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

8:40

OVEN TEMPERATURE:

320

FINISH TIME:

9:10

2^e rack

start time 8:55

oven temp 320

finish time 9:23

3^e rack

start time 9:10

oven temp 320

finish time 9:40

08/07/01

RD/MLC

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

BL 08-07-01

(75)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

08/07/01 (75)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/02

Job Completion



UMF 08-07-02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

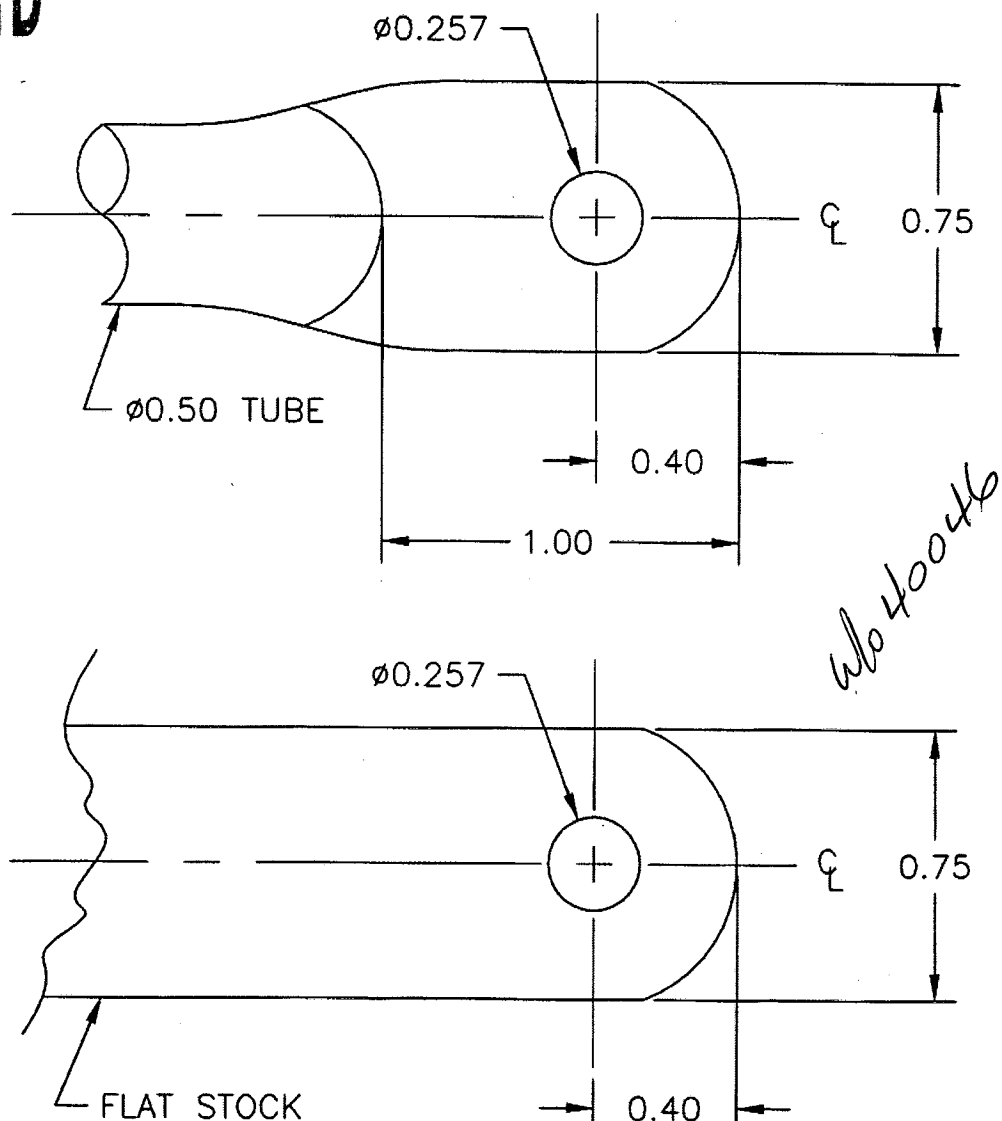
NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>DM</i>	APPROVED <i>CA</i>	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL	SCALE 2:1
A	97.11.24	NEW ISSUE	
A1	<i>#CP</i> 01.12.20	ADD TOLERANCE NOTE	

SPECIFICATION CONTROL DRAWING
FOR PUNCH DT8012

RELEASED
98/03/06 *KE*



NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



Dart Aerospace Ltd

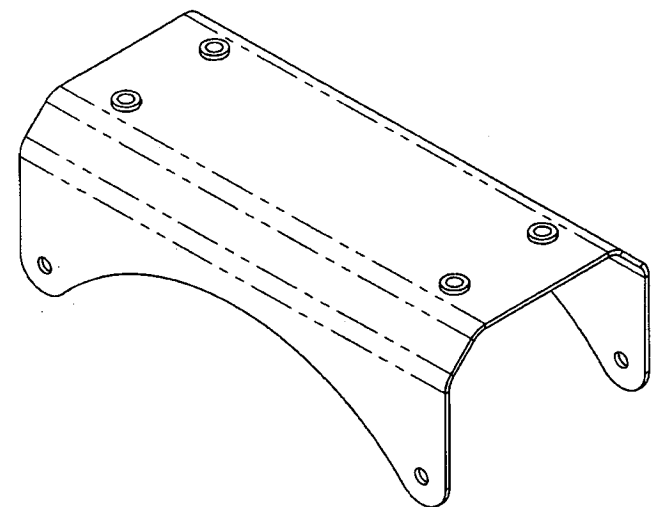
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

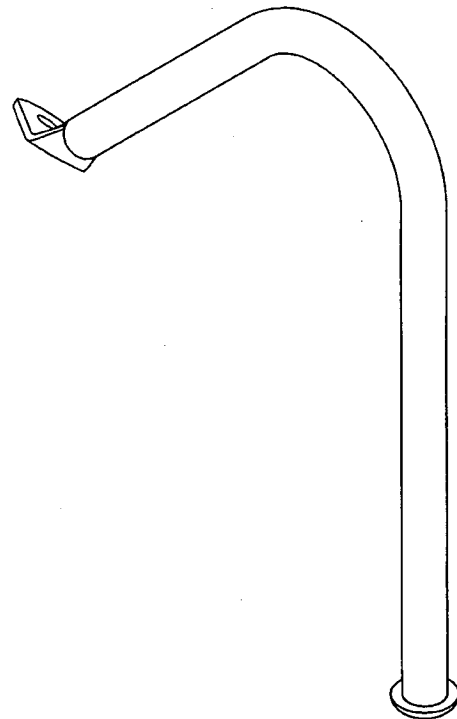
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

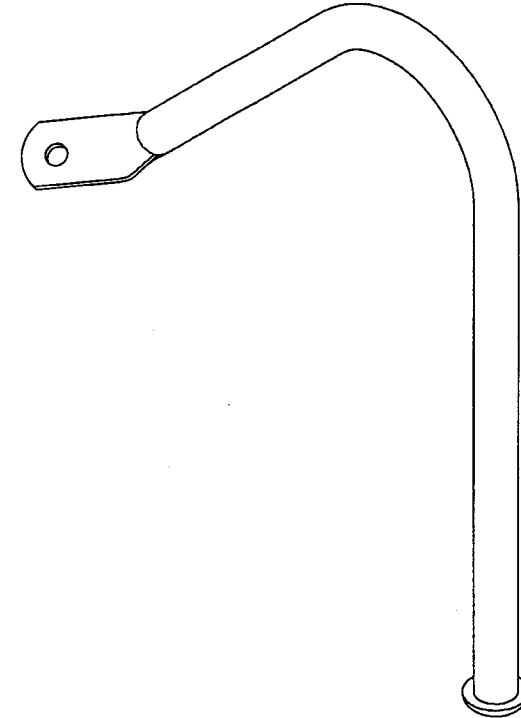
NOTE: Date & initial all entries



D2010-101 MIRROR BRACKET



D2010-103 ARM



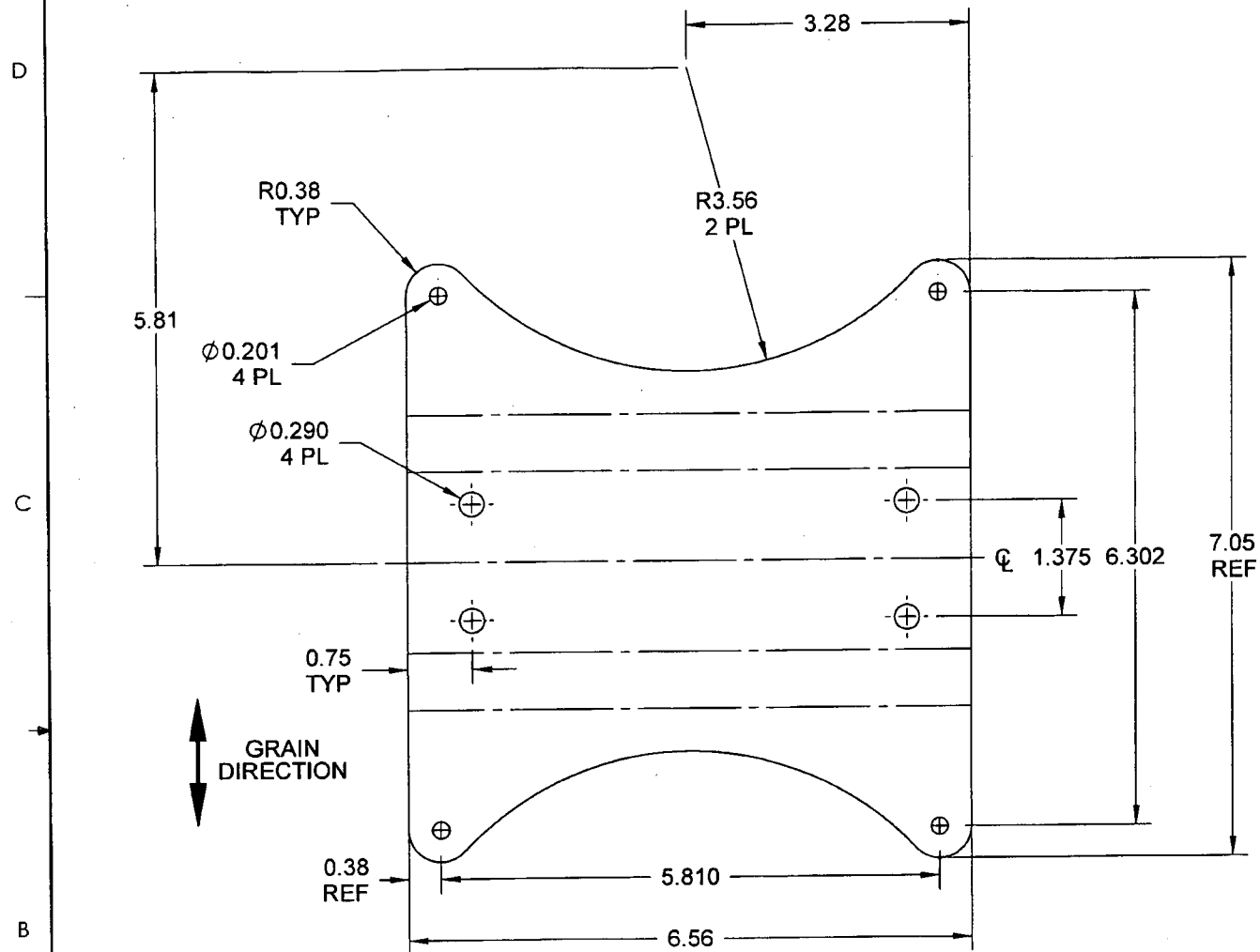
D2010-104 ARM

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 08.06.10

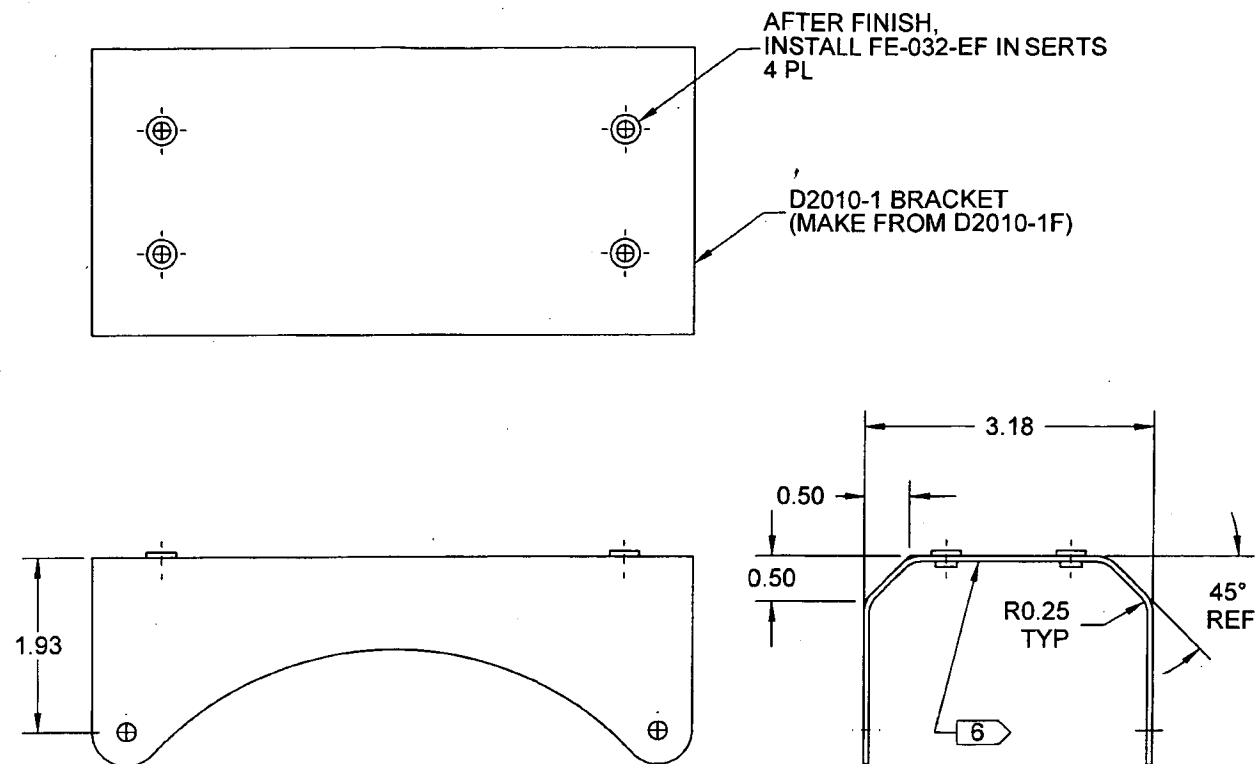
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D	REDRAWN IN SOLIDWORKS; ADD D2010-1F FLAT PATTERN FOR D2010-101 (ZN B7-2); Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN B1-3, B1-4); REASON; TUBING CRACKING DURING SERVICE	PH	08.06.10
C	1.93 WAS 2.00; 0.50 WAS 0.62	KE	97.10.31
B	7.90 WAS 10.90	JB	92.03.17
A	NEW ISSUE	JB	90.12.15
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2010	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MIRROR BRACKET	NTS
DATE	08.06.10	COPYRIGHT © 1990 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

QTY -101	P/N	DESCRIPTION
X	D2010-101	MIRROR BRACKET
1	D2010-1	BRACKET
4	FE-032-EF	INSERT



D2010-1F FLAT PATTERN



D2010-101 MIRROR BRACKET

NOTES:

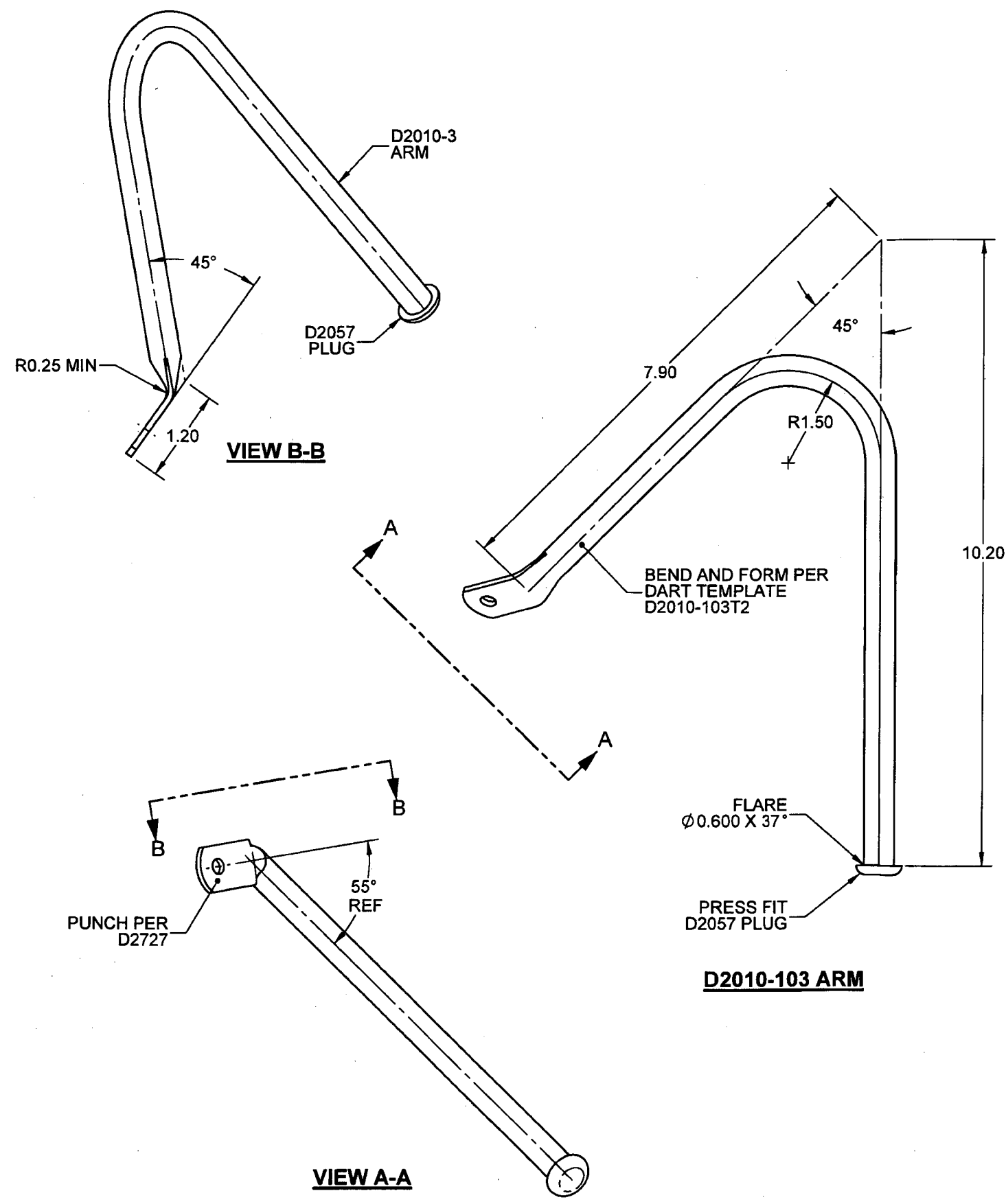
- 1) MATERIAL: D2010-1F: 2024-T3 ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-101" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
- 7) WEIGHT: 0.23 lbs

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MFG. APPR.	AP	D2010	SHEET 2 OF 4
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08.06.10

QTY -103	P/N	DESCRIPTION
X	D2010-103	ARM
1	D2010-3	ARM
1	D2057	PLUG



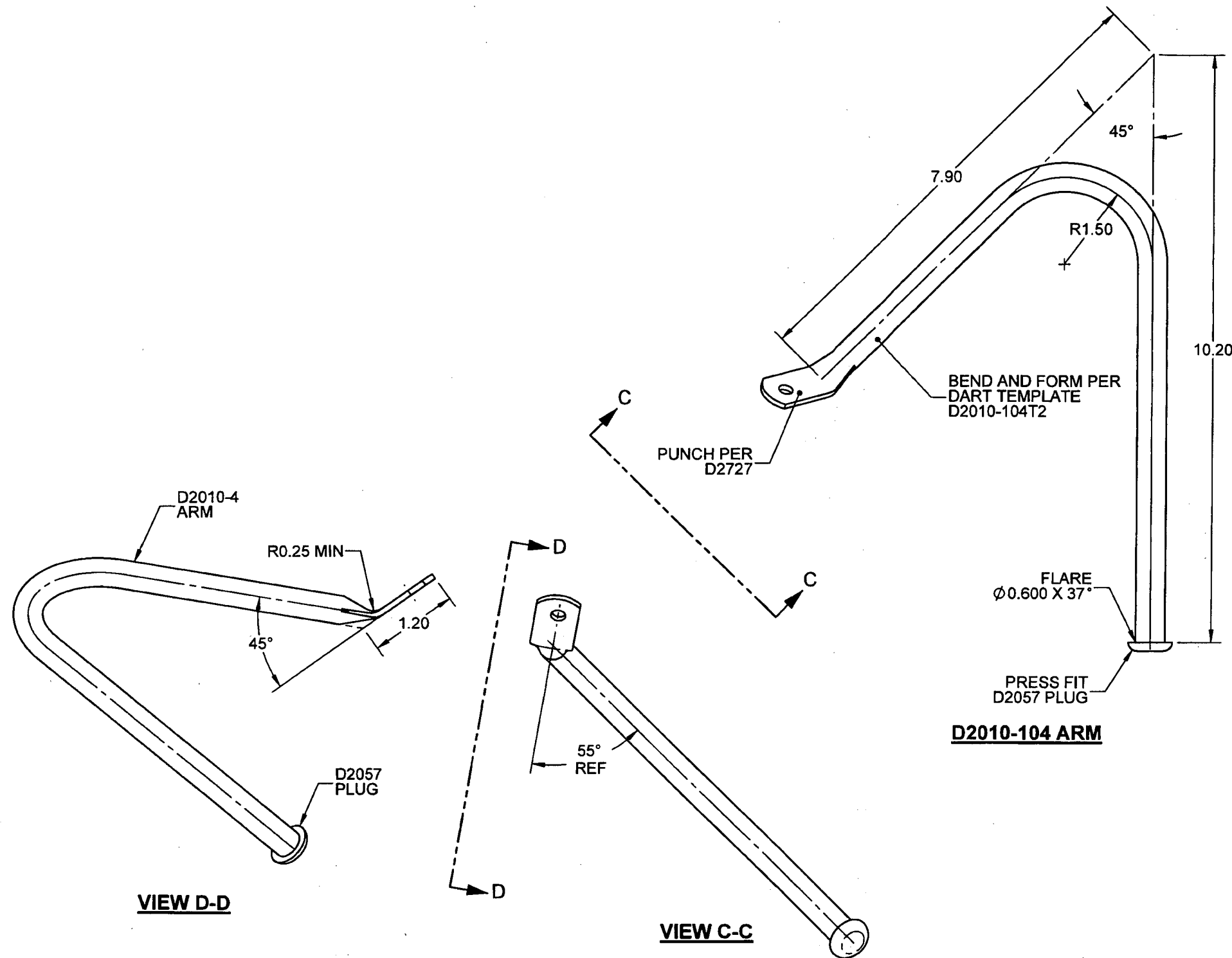
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- NOTES:
- 1) MATERIAL: D2010-3: AISI 304/316 SS SEAMLESS ROUND TUBING
Ø 0.500 X 0.049 WALL
(REF DART SPEC M304TR0.500W.049) Δ SUBJECT TO AMENDMENT
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART WITHOUT NOTICE
QSI 005.4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-103" USING WHITE FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.34 lbs

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QTY -104	P/N	DESCRIPTION
X	D2010-104	ARM
1	D2010-4	ARM
1	D2057	PLUG



RELEASED
08-06-19-11

- NOTES:**
- 1) MATERIAL: D2010-4: AISI 304/316 SS SEAMLESS ROUND TUBING, $\varnothing 0.500 \times 0.049$ WALL (REF DART SPEC M304TR0.500W.049) \triangle
 - 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-104" USING WHITE FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.34 lbs

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